Quality Control

13-06-63

		DQA:	Date:	*
				<del></del>
NCD V / N-	MODE ODDED MON CONFORMANCE / LIDDATE			

NCR: Y	es'	/ No				WORK ORDER NON-C	JU.	MFORM	MANCE / UPI	DAIE						
		•		•					-		QA Closed:	Dat	e:			
Work Orde	er:					DISPOSITION	ION AGAINST DEPARTMENT/PROCESS									
Part N	•					Rework Scrap Use-as-is		1	Skid-tube Machining noforming	ining Small Fab Prod. Eng. Coor. Quali						
NCR N	۱o. ِ					Work Order Update			Large Fab	Composite	1130,515	Supplier				
Root					Descri	ption of work order update		nitial	Act	tion	Sign &					
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	n QC Inspector			
Doc/Data			ł													
Equip/Tooling							l									
Operator	Щ															
Material			1													
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Other																
Process			1													
Supplier	_				Ì											
Training	_															
Unapproved	L	<u> </u>		<u>1</u>	!	Ε.		T CATE	SORV		<u> </u>	<u> </u>				
Landi	na (	Goar				General	AUL	CAIL	<u> </u>							
Landi		Bending				Bend	$\Gamma$	Grain			Ovalized	Γ	Pressure/Forced			
	┢	Centre No	ot Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa	ire		Over/Under	tolerance	Temperature/Cure			
	$\vdash$	Cracks			·	Broken/Damaged		4	ion Incomplete		Part Incorre	+	Weld			
		Crushed/	Crimped			Burrs		1	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled			
		Cuffs	•			Contamination	$\vdash$	Mainte			Part Moved		<del></del>			
	Г	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong				
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	. t		Power Loss/	Surge [	Other			
		Ripples in	Bend			Drill Holes		Offset		<del></del>						
		Torque W	Vaves in I	Extrusio	n [	Drawing		Out of	Calibration							
		Turning S	equence	<b>!</b>		Finish		Out of	Sequence							

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

130

QC8- Inspect parts - second check

0.00

\*130\*

Quality Control

QC Quality Control

Memo

0.00

SS 13-07-05

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NCR:	⁄es	/ No	:			WORK ORDER NON-	COI	NFORM	/IANCE / UP	DATE	QA Close	d: Da	te:	
						DISPOSITION				ACAINST		IT/PROCESS		
Work Orde	er:					DISPOSITION				AGAINSI D		11/PROCE33		
	-					Rework	7		Skid-tube	Crosstube	7	Water Jet		Engineering
Part f	No.					Scrap	7	i r	Machining	Small Fab	P	rod. Eng. Coor.		Quality
						Use-as-is	1	Therm	noforming	Finishing	Rec/St	ore/Packaging		Other
NCR I	NCR No Work Order U						]		Large Fab	Composite		Supplier		
Root					Descri	tion of work order update	T	Initial	Ac	ction	Sign &			
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		Centre N	ot Conce	ntric to	o/s	BOM/Route	$\perp$	Hardwa		L	<b>⊣</b>	er tolerance	-	Temperature/Cure
Cracks Broken/Damaged					L	- '	on incomplete	L	Part Incor		-	Weld		
Crushed/Crimped Burrs						-	ions Incomplete,	/Unclear	Part Lost/		Ш	Wrong Stock Pulled		
		Cuffs				Contamination	$\perp$	Mainte		L	Part Moved			
		Heat Trea	at			Countersink	L	Mislabe	eled	L	Positioned Wrong			
1	1	Inspectio	n Strip in	Tube		Cut Too Short	-	Misread	1		Power Los	ss/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

# .							٠				
<b>Work Ord</b> <i>May-13-13 1:1</i>		1669 <b>p 3</b> <b>B 1</b>	205-1 01669	*101	669*	n tu arresta	7	i	1222 2021 100 2011		Page 3
Item ID: Revision ID: Item Name:	D3205-1 Pedal Bracket	21	·	Accept	*N900	<b>040</b>	100	<b>*</b> s	etup St St		NS1* NS2*
Start Date: Required Date Reference:	5/15/13 : 5/31/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:					
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ıte:	<u> </u>	F		art *	NR1*
	QC:		Date:	SPC (Y/N):	Da	ite:			Si	top *	NR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Numb	-
*140 *140* HandFinish Hand Finishing		Chemical Conversion Co  Memo	at per QSI005 4.1	0.00				10	74	<u> 913</u>	-7-9
*150 *150* Powdercoat Powder Coating	7 Q	TIME:	the thread hole for D320	0.00  0.00  5-1 before powder coat.STA TEMPERATURE:	ART		10	Xg	(M)	41	3/07/0
160 *160* QC Quality Control	1-1	QC3- Inspect Part Finish  Memo		0.00				10x	-{	بالو	13/02/09

NCR:	Yes	/	No
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NCR:	Yes	/ No					WORK ORDER NON-C	CON	VFORM	AANCE / UP	PDATE	QA Closed:	 Dat	٠.				
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	•					١	Rework	]	Skid-tube Crosstube Water Jet Engi						Engineering			
Part I	No.		Scrap						ſ	Machining	Small Fab		d. Eng. Coor.		Quality			
						1	Use-as-is			oforming	Finishing	Rec/Sto	re/Packaging	$\Box$	Other			
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Root					Desc	crip	tion of work order update		nitial	Ac	ction	Sign &						
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	1	QC Inspector			
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	$\vdash$	Bending	at Cansa	ntric to 1	0/5	-	BOM/Route	$\vdash$	Hardwa	**	-	Over/Under	tolorance	_	Temperature/Cure			
	-	Centre No Cracks	ot Conce	ntric to t	0/3	_	·	$\vdash$	1	on Incomplete	-	Part Incorre	ł		Weld			
	$\vdash$	4 '	Broken/Damaged						4	ions Incomplete	/Unclear	Part Lost/M	<b>}</b>		Wrong Stock Pulled			
	$\vdash$	Cuffs	d/Crimped Burrs						Mainte	•	Officieal	Part Moved	1331118 [		Wrong Stock Fulled			
	$\vdash$	Heat Trea	$oldsymbol{arphi}$						Mislabe		 	Positioned \	Vrong					
		Inspection Strip in Tube Countersink						$\vdash$	Misread		<u> </u>	Power Loss/	- r		Other			
	$\vdash$	Ripples in		1450		$\vdash$	Drill Holes	$\vdash$	Offset	•	L		[					
		₫ ''		Extrusio	n	H	Drawing	-	-	Calibration								
	Torque Waves in Extrusion Drawing						•		Out of Sequence									

Outside Dimensions

Wave/Twist in Tube

Work Center ID  Description  Identify as per dwg & Stock Location:  Number Stamp  0.00  *170*  Packaging  Memo  One  One  Packaging  Number Stamp  0.00	<b>Work Ord</b> <i>May-13-13 1:1</i>		)1669		*101		,		. 4	Page 4			
Start Date:   5/15/13   Start Qty:   10.00   *1	Revision ID:		it		Accept	*N900	<b>040</b>	100	)*	Setup		I VI	•
Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N): SPC (Y/N): Date: SPC (Y/N): Date: SPC (Y/N): Date: SPC (Y/N): Date: SPC (Y/N): SPC (Y/N): Date: SPC (Y/N):	Required Date		_							·			
Work Center ID  Description  Identify as per dwg & Stock Location:  *170*  Packaging  Memo  Run Hours  0.00  Code Qty Qty Number Stamp  0.00	Approvals:		an:		_					Run		17	R1* R2*
Packaging	Work Center I 170 *170*	ID	<b>Description</b> Identify as per dwg & Sto	ock Location: GA	Run Hours 0.00	Tool ID	Tool #						Insp. Stamp

0.00

0.00

180

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Quality Control

QC21- Final Inspection - Work Order Release

Memo

NB01-10

			1
NCR:	Yes	/	No

										DQA:	Date:	1 ¥
NCR: Ye	es / No				WORK ORDER NON-	CON	IFOR <b>N</b>	/ANCE / UF	PDATE	QA Closed:	 Date:	
Work Ordei			<del></del>	· · · ·	DISPOSITION				AGAINST D	EPARTMENT		·
Part No			<del></del> ,	<del></del>	Rework Scrap			Skid-tube Nachining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	Use-as-is D. Work Order Update							oforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root Cause	Date	Description of work order update Initial Action  Date Step Qty or Non-conformance Chief Eng Description								Sign & Date	Verification	QC Inspector
quip/Tooling Operator Material etup Other rocess upplier		Step	Qty		·		Description				Vermedian	Qe inspector
Inapproved							T CATE	COBA		<u> </u>	<u> </u>	1
Landin	g Gear	<u> </u>	<del> </del>		General	AUL	CATE					
	Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Countersink Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing						Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete nance led	·/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
<u> </u>	Turning Sequence Finish						Out of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

## **Picklist Print**

May-13-13 1:11:13 PM

Work Order ID:

101669

Parent Item:

D3205-1

Parent Item Name:

Pedal Bracket

**Start Date: 5/15/13** 

Required Date: 5/31/13

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP A04.06.09New issueKJ/RF

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

IPP REV:C AS PER REV B 12-

	03-23 JLM VERIF					21101101		_					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.25 7075-T73 Bar 2.50 x 3.25		Purchased	No			100	f	8.0000	0.3646	3.837895	<i>!</i>		
				<b>Location</b>		Loc Oty	<u>Lo</u>	c Code		23	7 1	3-0	6-10
				MAT		8				Do ,			

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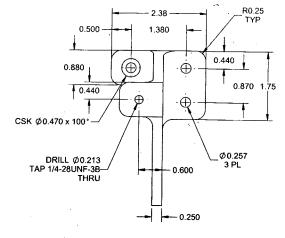
3.6

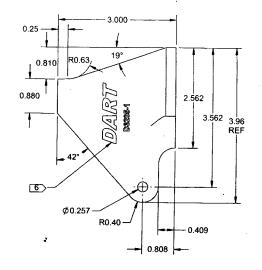
NCR:	Yes	1	No
IVCIV.	162	1	110

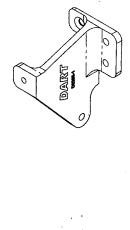
DQA:

Date:

NCR: Yes												
	:									QA Closed:	Date:	
Nork Order:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
TOTA OTGET					Rework	7 <b> </b>		Skid-tube	Crosstube	]	Water Jet	Engineering
Part No.	, i				Scrap	1	Machining Small Fab			Pro	d. Eng. Coor.	Quality
					Use-as-is	1   1	Thermoforming Finishing			4	e/Packaging	Other
NCR No	• '				Work Order Update	1		Large Fab	Composite	1	Supplier	
			<del></del>							_		
Root Description of work order update Initial Action Sign &									Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	QC Inspector
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Landing	Gear			_	General					7	_	<b>,</b>
L	Bending			_	Bend	ШG	rain		<u> </u>	Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Щ∺	ardwa	ire	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	l lr	spect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	L_Ir	struct	ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	^	1ainte	enance		Part Moved		
	Heat Trea	at		L	Countersink	\~	1islabe	eled		Positioned V	Vrong	, ·
	Inspectio	n Strip in	Tube		Cut Too Short	∿	1isrea	t		Power Loss/	Surge	Other
	Ripples in Bend Drill Holes Offset											
	Torque V	Vaves in I	Extrusio	n [	Drawing		ut of	Calibration				
	Turning S	Sequence	!		Finish		ut of	Sequence				
Wave/Twist in Tube Folio Outside Dimensions												







1.100 0.250 <u>&</u> R0.38 0.250

101669 MCJ 13-05-15 11 2013-02-07

## **D3205-1 PEDAL BRACKET**

4

5

NOTES:
1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T738
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
7) WEIGHT: 0.28 lbs

8

REMOVED GRAIN DIRECTION ON -1 (ZN B5-1) SEE PREVIOUS REV. FOR DETAILS. REF. PAR12-212 12.12.24 CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1); 19° WAS 18° (D3-1); 42° WAS 41° (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. Pt. (ZN D5-1, D6-1, C4-2); D5-2; C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3. RF 12.02.24

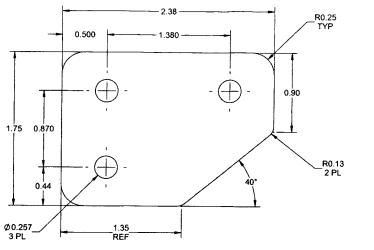
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	WISSUE			RF	04.01.27	
REV.	DESCRIPTION				DATE	
DESIGN RF			DART AEROSPACE LTD			
DRAWN		SFM	HAWKESBURY, ONTARIO, CANADA			
CHECKE	. O	1	DRAWING NO.		REV. C	
MFG. AP	PR.	1 H	D3205		SHEET 1 OF 2	
APPROV	ت ED	W	INTE		SCALE	
DE APPE	₹   -	-#-	BRACKET		NTS	
DATE 12.12.24			COPYRIGHT 6 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS COMPITION THAT IT IS			

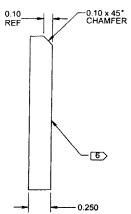
3

FROM DART AEROSPACE LT

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**D3205-3 BACK PLATE** 

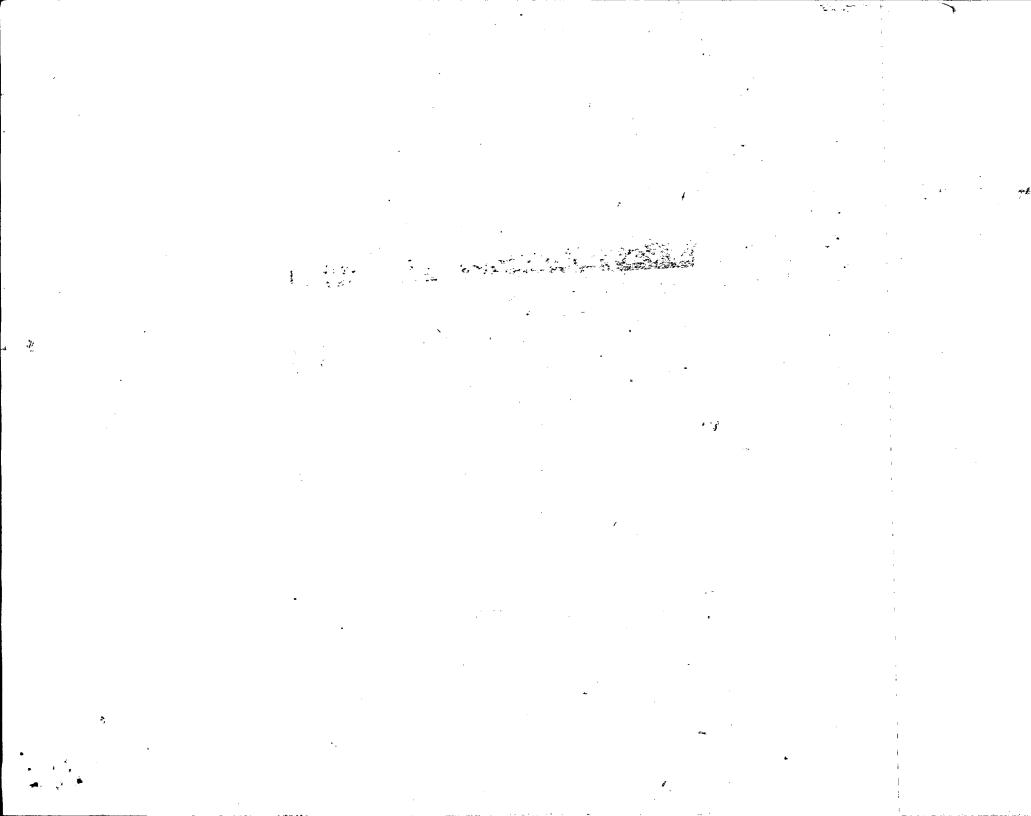
DELEASED 2013 -02- 07

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.09 lbs

D

		<del></del>		
DESIGN	RF.	■ DART AEROSE	PACELID	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA		
CHECKED	-21	DRAWING NO.	REV. C	
MFG. APPR.	12/11	TD3205	SHEET 2 OF 2	
APPROVED	WD	TITLE	SCALE	
DE APPR.	-#-	BRACKET	NTS	
DATE 12.	12.24	COPYRIGHT © 2004 BY DART THIS DOCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLIED TO ANY PURPOSE OF CORPED ON COMMUNITY TO BE USED FOR ANY PURPOSE OF COMPED ON COMMUNITY PURPOSES OF PROMISE.	LIED ON THE EXPRESS CONDITION THAT IT IS INCATED TO ANY OTHER PERSON WITHOUT	

2



DART AEROSPACE LTD	Work Order:	101669
,		
Description: Pedal Bracket	Part Number:	D3205-1
<u> </u>		
Inspection Dwg: D3205 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.103			vacon	25-4
0.250	+/-0.010	251				
R0.38	+/-0.030	380	/			
0.125	+/-0.010	. 128				
0.250	+/-0.010	.252				
2.380	+/-0.010	2.383				
1.380	+/-0.010	1.378				
0.500	+/-0.010	, 500		-		
0.880	+/-0.010	.879				
Ø0.470 x 100°	+0.006/-0.001	0,473			MJP-04	Wern
0.440	+/-0.010	.437				
0.600	+/-0.010	.593			*	
1/4-28UNF-313	N/A					
0.250	+/-0.010	250				
Ø0.257	+0.006/-0.001	1258	/			
1.750	+/-0.010	(.770				
0.870	+/-0.010	870				
0.440	+/-0.010	.440				
R0.25	+/-0.030	-250				
3.000	+/-0.010	2.999				
3.96	+/-0.030	3.964			hightgunge	31006
0.409	+/-0.010	.412			7 / 2	
0.808	+/-0.010	. 8/0				
2.562	+/-0.010	2.563				

Measured by: Se At 02

Date: 2013-06-1269

Audited by: St. Preliminary Approval:

Date: 13-07-05

Date:

		Approved
New Issue	KJ/JLM	
Dimensions updated per Dwg Rev B	KJ a	
	<del></del>	M
	Dimensions updated per Dwg Rev B	Dimensions updated per Dwg Rev B KJ